

Date: Thursday, 5/10/2007 2:26:45 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP MOUNTING LUG
Job Number	: 32292		
Estimate Number	: 11747		
P.O. Number	: <i>N/A</i>	Part Number	: D34591
This Issue	: 5/10/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3459 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 30909	Material	: <i>N/A</i>
Written By	: <i>ADJ. 05.10</i>	Due Date	: 5/17/2007
Checked & Approved By	: <i>ADJ. 05.10</i>	Qty:	20 Um: Each
Comment	: Est Rev: A New Issue 06-01-06 JLM Est Rev: B Waterjet 06-05-23 ec		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0187X04000 6061-T6 Bar .178" x 4.0"



Comment: Qty.: 0.3644 f(s)/Unit Total : 7.2870 f(s)
4.00" X .188" BAR
6061-T6
(M6061T6B4.000X.188)
Batch: *1103857X ml 07 05 21*

(20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3459
Dwg Rev: *A*
Prog Rev: *A*

ml 07 05 21

(20)

2-Deburr if necessary

mf 07-05-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 07 05 21



(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



207-05-22 (20)



Comment: SECOND CHECK

counted

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *WA24*

RG 07-05-31

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 01/06/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:26:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP MOUNTING LUG

Job Number: 32292

Part Number: D34591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

207/06/01

Job Completion



U OF 1001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

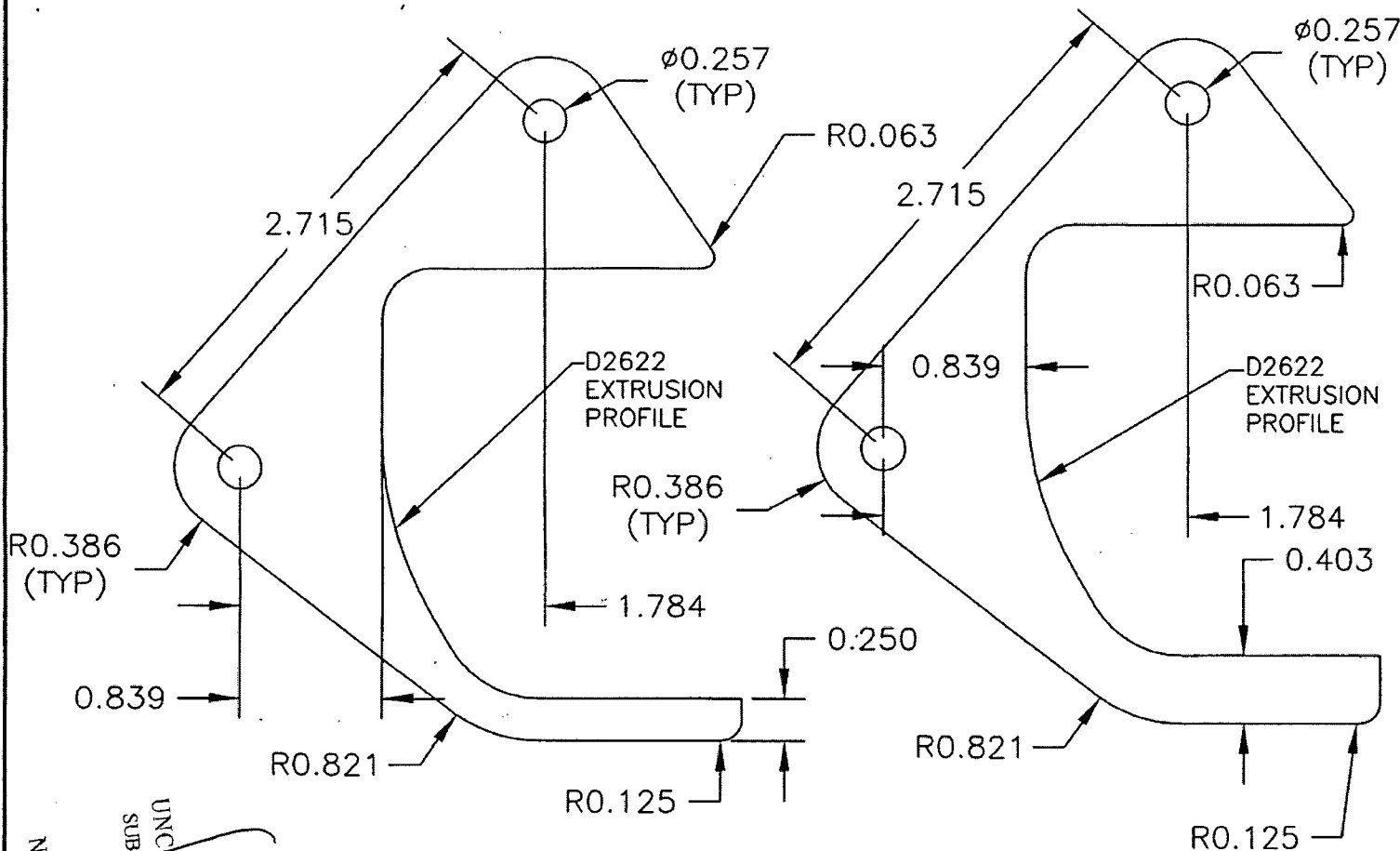
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	
DATE	05.09.23	DRAWING NO.	D3459		SHEET 1 OF 1
		TITLE	Float Step Mounting Plate		SCALE
			NEW ISSUE		1:1



D3459-3 FLOAT STEP MOUNTING PLATE

D3459-1-2 FLOAT STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK (REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14

UNCONTROLLED
SUBMIT TO AN END USER
WITHOUT NOTICE
WORK ORDER
NO 52292

DART AEROSPACE LTD		Work Order: 32292
Description: Beampaw Front Step Mounting Lug		Part Number: D3459-1
Inspection Dwg: D3459 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.257$	$\pm 0.006 - 0.001$	0.261	✓		VEN	
B 2.715	± 0.010	2.715	✓		VEN	
C 0.250	± 0.010	0.255	✓		VEN	
D 0.839	± 0.010	0.841	✓		VEN	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MM. MM</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07.05.20	Date: 02.05.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	